

**Work Order ID 52296**

Tuesday, September 22, 2009 1:57:34 PM



Page 1

Item ID: D3927-1

Accept



Setup Start



Revision ID: A

Item Name: Guard

Stop



Start Date: 9/23/2009 Start Qty: 5.00



Cust Item ID:



Required Date: 10/9/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

*RL MK*Date: *09-9-22*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3927

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as file D3927-1\_Blank

*B 9-9-29*

110

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

HAAS

*8.8 09/10/27**6*

1-Mill as per folio FA &amp; dwg D,

FOLIO REV: *AA*DWG REV: *A*

2-Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3927-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: HA Date: 09-11-06

Resolution: ae Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 52296		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/07	#100	0.257" holes are no longer holes are 0.270" R.C. Tap from water set	<u>OS.10.27</u> pu 05/04/12	Acceptable Tapping hole only	<u>8/8</u> 09/10/07	<u>S</u> 09/10/06	<u>OS.10.27</u> pu 05/04/12	<u>S</u> 09/10/07

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

*SL 09/10/27*6

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

*SL 09/10/28***POSITIVE RECALL**EFFECTIVE 09.10.27 AUTH PRELEASED GP DATE 09.10.27

QC

Memo

0.00

Quality Control

140

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

9/10/29 (40) SD

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Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/30

MF  
09-10-29

# Picklist Print

Page 1

Tuesday, September 22, 2009 1:57:33 PM

Work Order ID: 52296



Parent Item: D3927-1RevA



Parent Item Name: Guard

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments: Rev:A new issue

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MDELRLNB1.000X04.0 00	"	Purchased	No			100	f	26.0000	7.1579			

1.000X5.0



9-9-09

Delrin Bar

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

26

111695

10

112665

16

112782

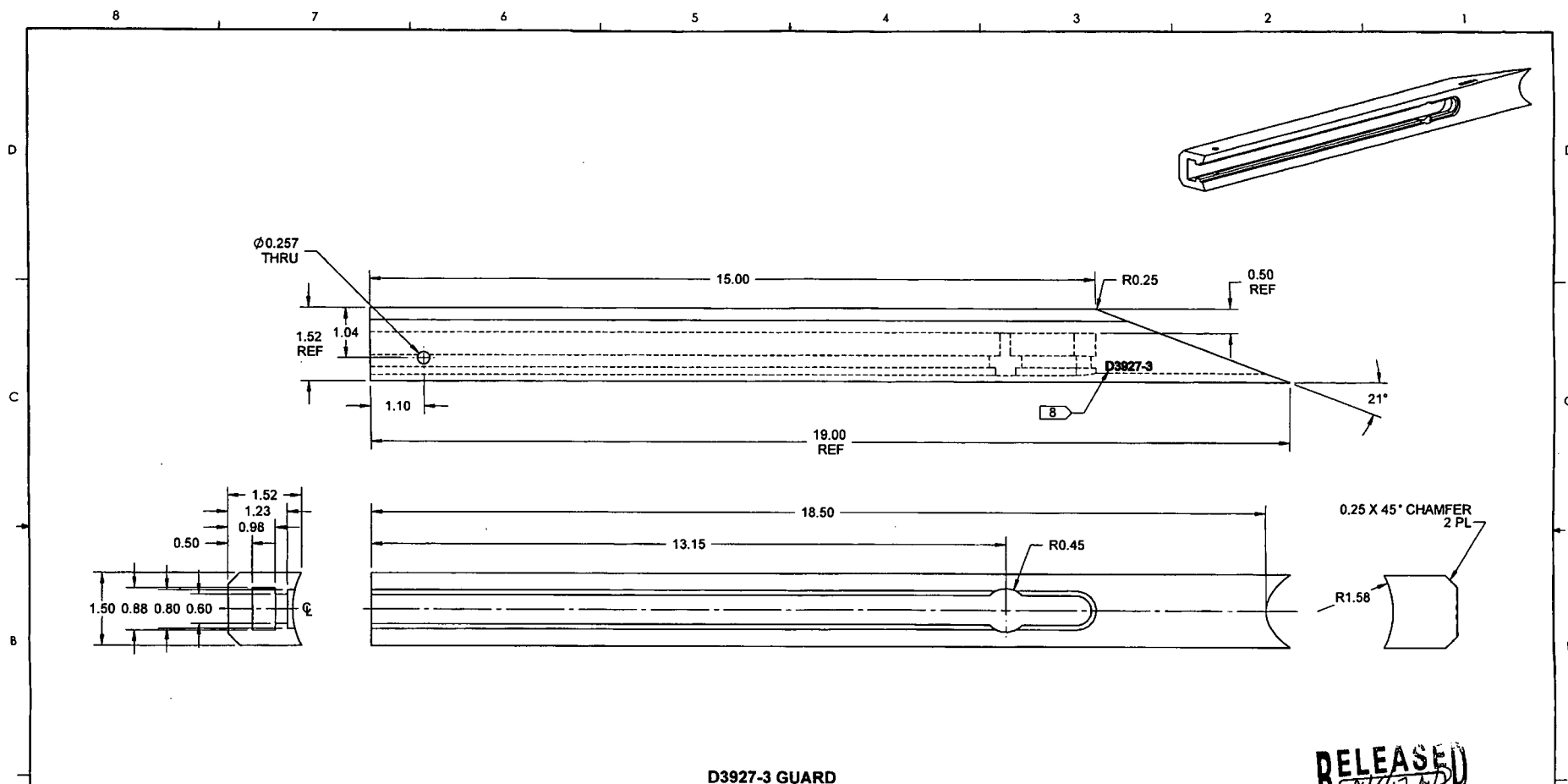
~~111695~~

112782





52296



**D3927-3 GUARD**

RELEASED

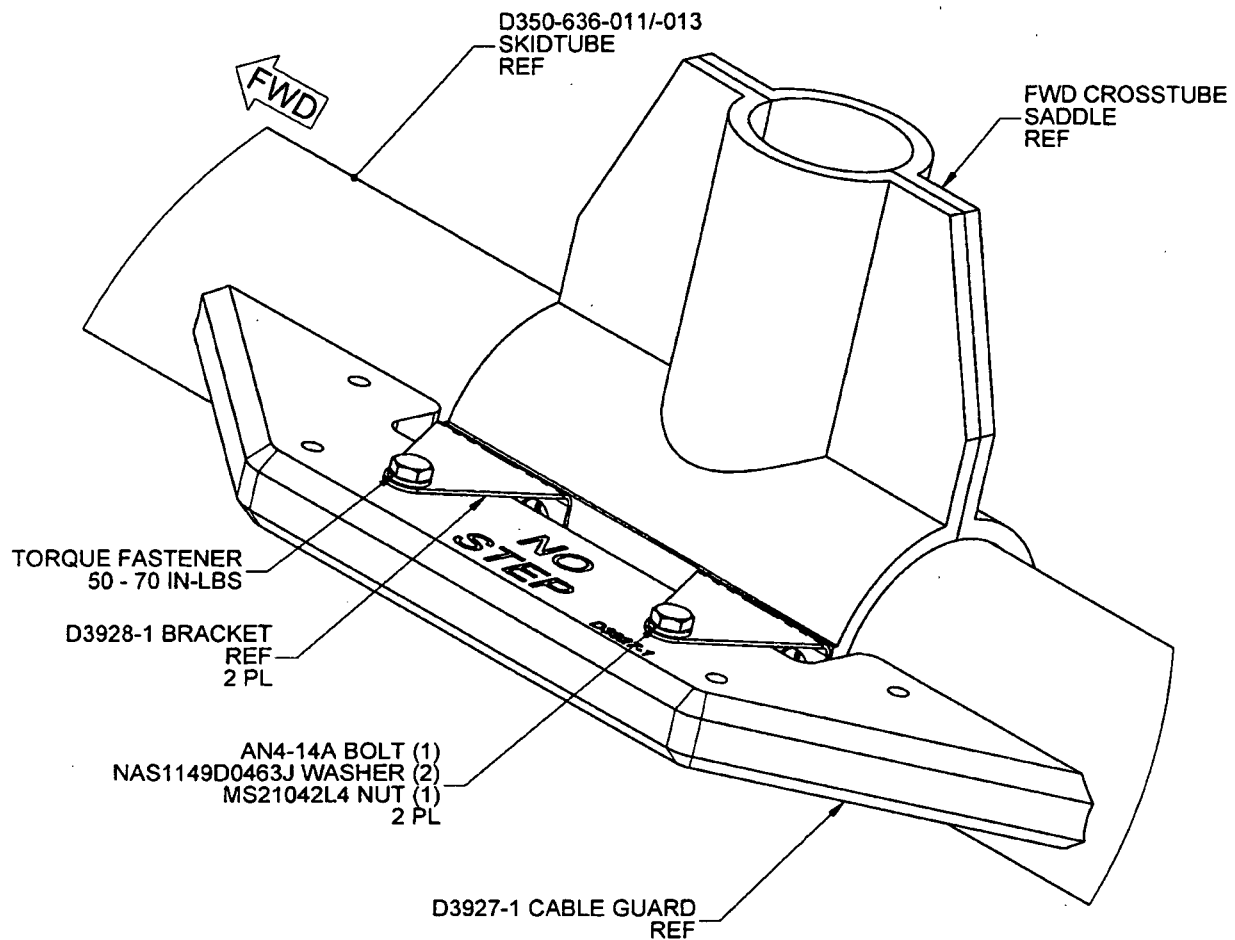
**NOTES:**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL 1.5 THICK  
PER DART SPEC M-DELRIN-S1.5
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.82 lbs
- 8) ENGRAVE "D3927-3" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015±0.005 IN LOCATION INDICATED

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3927	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GUARD	NTS
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REFERENCE ONLY



**FIGURE 2: D350-636-107A FWD CABLE GUARD KIT**  
ATTACH BOLTS NOT SHOWN FOR CLARITY

52296

DESIGN	<i>AS</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	<i>AS</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9457	SHEET 3 OF 4
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	CABLE GUARD KITS	NTS
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